Item ID:

D4131-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Manifold Assembly

**Start Date:** 

**Required Date:** 10/15/2010

10/8/2010

Start Qty: 2.00

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Weld per dwg A/R S.S. rod Batch: 11586

Date: 10-10

Date:

Run

Qty

Start Stop



SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Number Insp. Stamp

Work Center ID Draw Nbr

**Revision Nbr** 

Operation

Description

D4131

Sequence ID/

Α

Large Fab Large Fab

100

'Memo

0.00

0.00

0.00

0.00

110

Memo

Memo

QC9- Inspect visual per QSI004- Fusion Welds

Quality Control

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Sideolas

0.00

MATERIAL CERTIFICATION

Dart Aerospa	ace Ltd
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W/O:	WO: WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								Floa Wigi	·	
			- War - San							
	:									
Part No		PAR #:	Fault Cate	_ NCR: Yes No DQA: Date:						
Resolution:			Disposition	_ QA: N/C Clo	sed:		Date: _			
NCR:		ž	WORK ORD	ER NON-CONFORMA	NCE (NCR)					
DATE	CTED	Description of NC Section A		Corrective Action Section		Verific	ation	Approval	Approval	
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector	
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				A CONTRACTOR OF THE STATE OF TH						
									ro I	

Friday, October 08, 2010 10:38:00 AM

Item ID:

D4131-041

Accept



Setup Start



Stop

**Revision ID:** 

Item Name:

Manifold Assembly

**Start Date:** 

10/8/2010

Start Qty: 2.00

**Required Date: 10/15/2010** 

**Req'd Qty: 2.00** 



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging

Operation Description

Identify as per dwg & Stock Location: \$7/3/

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp.

Number Stamp

Packaging

140

Quality Control

Memo

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MF-01

Dait Ac	Space	LU								₹ ·			
W/O:			WC	ORK ORDER CHANGI	ES								
DATE	STEP	PRO	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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<del> </del>													
Part No	:	PAR #:	Fault Cate	gory:	NCR: `	Yes N	o <b>DQ</b>	<b>A</b> :	Date:				
Resolution:			Dispositio	n:	_ QA: N/	C Clos	sed:		Date: _				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip		Section B on Sign &				Approval Chief Eng	Approval QC Inspector			
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### **Picklist Print**

Friday, October 08, 2010 10:38:04 AM

Work Order ID: 62807

Parent Item:

D4131-041

Parent Item Name: Manifold Assembly



**Start Date: 10/8/2010** 

**Required Date:** 10/15/2010

Page 1

Start Qty: 2.00

Required Qty: 2.00

**Comments:** 

IPP Rev:A 10.10.06 new issue DD verf:EC

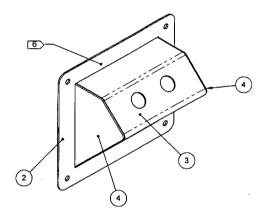
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4131-1 Front Plate		Manufactured	No			100	Each	0.0000	B63	2 80 <b>65</b> -	<b>-</b> ##	Plio	.10.22
D4131-3		Manufactured	No			100	Each	0.0000	1 1 B6	<sup>2</sup> 3 <b>066</b> -	<del>&gt;</del> (4)	Cl	0.10.23
D4131-5		Manufactured	No			100	Each	0.0000		4 : B63	067-	' →&	Col 10.

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								Prod Mgr			
-											
								<u> </u>			
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _			
Resolution:			Disposition: QA			losed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)					
DATE	CTED	Description of NC		ion B	Verifi	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector		
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NO. 42507 PS101008

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	Х	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-1	FRONT PLATE
3	1	D4131-3	BASE
4	2	D4131-5	SIDE PLATE



#### **D4131-041 MANIFOLD ASSEMBLY**

С

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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.64 lbs

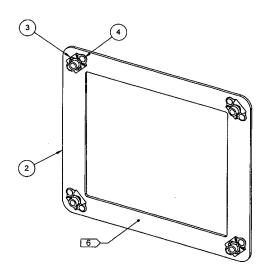
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Α	NEW ISS	UE		RF	10.09.16			
REV.			DESCRIPTION	BY	DATE			
DESIGN		RF	DART AEROSPACE	USA	INC			
DRAWN	ı	RF	PORT HADLOCK,		,			
CHECK	ED	10	DRAWING NO.		REV. A			
MFG. A	PPR.	N	D4131		SHEET 1 OF 8			
APPRO	VED	149	TITLE		SCALE			
DE APP	R.	-41-	MANIFOLD ASSEMBL	Y	NTS			
DATE	10.09	9.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THE DOCUMENT OF PRIVATE AND COMPENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPANION AND TO TO ANY OTHER PERSON WITHOUT					

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
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Resolution:												
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DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector			
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PART NUMBER ITEM DESCRIPTION D4131-043 DOUBLER ASSEMBLY 1 2 1 D4131-7 DOUBLER 3 4 M521069L3 NUT PLATE 4 8 MS20426AD3-3 RIVET



w/o 42807

**D4131-043 DOUBLER ASSEMBLY** 

D

С

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE US	A. INC.				
DRAWN	RF	PORT HADLOCK, WA					
CHECKED	140	DRAWING NO.	REV. A				
MFG. APPR.	77	D4131	SHEET 2 OF 8				
APPROVED	149	TITLE	SCALE				
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#### **D4131-041 MANIFOLD ASSEMBLY**

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.64 IBS
8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE US	A. INC.					
DRAWN	RF	PORT HADLOCK, WA						
CHECKED	140	DRAWING NO.	REV. A					
MFG. APPR.	77	D4131	SHEET 3 OF 8					
APPROVED	140	TITLE	SCALE					
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DATE 10.0	9.16	COPYRIGHT © 2010 BY DART AEROSPAC	MESS CONDITION THAT IT IS					

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8 7 5 3 2 ul 62867 Ø0.191 4 PL R0.31 TYP 0.405 4.600 2 PL С 4.000 3,480 4,81 0.405 2 PL 0.67 + 2PL 0.050 0.75 REF 3.914 2 PL 5.41 REF В **D4131-1 FRONT PLATE** NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET PER MIL-5-10 (304)
OR AMS 55-10 (304)
OR ASTM A240
OR ASTM A240
PER DART SPEC. M304S18GA DESIGN RF DART AEROSPACE USA, INC. DRAWN RF 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.18 lbs PORT HADLOCK, WA DRAWING NO. CHECKED REV. A D4131 MFG. APPR. SHEET 4 OF 8 APPROVED TITLE SCALE DE APPR. MANIFOLD ASSEMBLY NTS COPYRIGHT © 2010 BY OART AEROSPACE USA, INC.
THE DOCUMENT IS PRIVATE AND DISPREVING, AND SUPPLED ON THE EXPRESS CONSTITUTING INTO THE USED FOR ART PURPOSS OF COMPONIO ADMINISTRATION TO THE PURSON WITHOUT WRITTEN PERMASION FROM DART AEROSPACE USA, INC. DATE 10.09.16 8 7 5 6 3

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DATE	STEP	Description of NC	Corrective Action Section		on B			ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
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0.050 REF R0.13 2 PL REF 3.37 REF

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D4131-3 BASE MAKE FROM D4131-3F FLAT PATTERN

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NOTES:
1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN

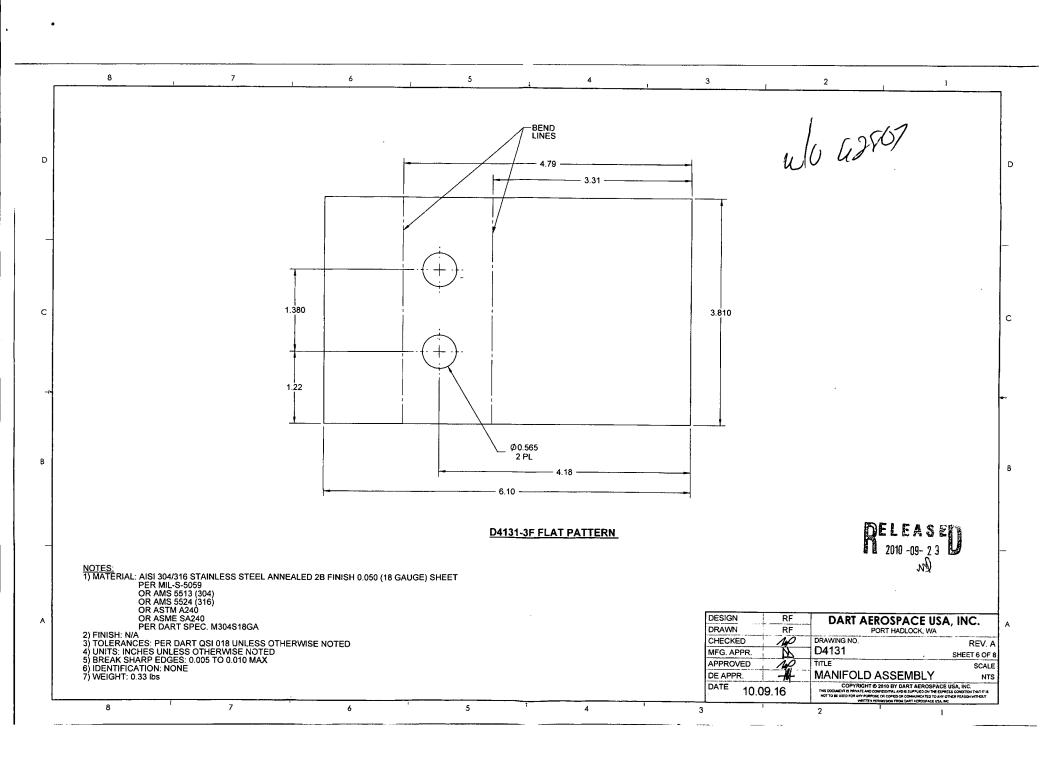
1) MAI ERIAL: MAKE FROM D4131-3F FLAT PATTERN
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.33 lbs

7

DESIGN DART AEROSPACE USA, INC. DRAWN RF PORT HADLOCK, WA DRAWING NO. CHECKED REV. A D4131 MFG. APPR. SHEET 5 OF 8 APPROVED TITLE SCALE DE APPR. MANIFOLD ASSEMBLY √ NTS COPYRIGHT @ 2010 BY DART AEROSPACE USA, INC.)
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Resolution:		solution:	Disposition:			QA: N/C Closed:			
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCI	R)			
DATE		Description of NC	Corrective Action S		on B	Verifi	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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8 w/0 62807 D D - 2.320 - 1.310 <del>---</del> R0.15 3.454 3.369 В **D4131-5 SIDE** 

NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET PER MIL-5-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASTM A240 OR ASME SA240 PER DART SPEC. M304S18GA

Α

PER DART SPEC. M304S18GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.07 lbs

0.050	
<u>E PLATE</u>	
	DELEASED N 2010 -09- 23
	In Inc.

DESIGN RF		DART AEROSPACE USA, INC.				
DRAWN	RF	PORT HADLOCK, WA				
CHECKED	140	DRAWING NO.	REV. A			
MFG. APPR.	77	↑D4131	SHEET 7 OF 8			
APPROVED	140	TITLE	SCALE			
DE APPR.	-#-	MANIFOLD ASSEMBLY	NTS			
DATE 10.0	9.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND COMPRISHING AND ESTIMATOR IS SUPPLIED ON THE EXPRESS CONCIDENT THAT IT IS NOT TO BE USED FOR ANY PRIPAGES OR COMMANDENTED TO ANY OTHER PERSON WITHOUT				

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W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
Resolution:			Disposition:		QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	)	ion C	Approval Chief Eng	QC Inspector
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8 3 w/062869 Đ D B2-7 0.405 4.600 2 PL 2 PL Ø0.098 CSK Ø 0.174 x 100° С 8 PL 4.000 2 PL 3.64 4.81 0.500 0.250 0.59 0.405 \_\_ 0.063 2 PL 0.66 DETAIL A D5-7 **D4131-7 PLATE** NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS4027 OR ASTM B209 PER DART SPEC. M6061T6S0.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: NONE 7) WEIGHT: 0.07 lbs

DESIGN DART AEROSPACE USA, INC.
PORT HADLOCK, WA DRAWN RF DRAWING NO. CHECKED REV. A D4131 MFG. APPR. SHEET 8 OF 8 APPROVED TITLE SCALE DE APPR. MANIFOLD ASSEMBLY DATE 10.09.16

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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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